

§ 54.10-10

46 CFR Ch. I (10-1-11 Edition)

[USCG-2003-16630, 73 FR 65167, Oct. 31, 2008]

§ 54.10-10 Standard hydrostatic test (modifies UG-99).

(a) All pressure vessels shall satisfactorily pass the hydrostatic test prescribed by this section, except those pressure vessels noted under § 54.10-15(a).

(b) The hydrostatic-test pressure must be at least one and three-tenths (1.30) times the maximum allowable working pressure stamped on the pressure vessel, multiplied by the ratio of the stress value “S” at the test temperature to the stress value “S” at the design temperature for the materials of which the pressure vessel is constructed. The values for “S” shall be taken from Tables UCS 23, UNF 23, UHA 23, or UHT 23 of section VIII of the ASME Boiler and Pressure Vessel Code (incorporated by reference, see 46 CFR 54.01-1). The value of “S” at test temperature shall be that taken for the material of the tabulated value of temperature closest to the test temperature. The value of “S” at design temperature shall be as interpolated from the appropriate table. No ratio less than one shall be used. The stress resulting from the hydrostatic test shall not exceed 90 percent of the yield stress of the material at the test temperature. External loadings which will exist in supporting structure during the hydrostatic test should be considered. The design shall consider the combined stress during hydrostatic testing due to pressure and the support reactions. This stress shall not exceed 90 percent of the yield stress of the material at the test temperature. In addition the adequacy of the supporting structure during hydrostatic testing should be considered in the design.

(c) The hydrostatic test pressure shall be applied for a sufficient period of time to permit a thorough examination of all joints and connections. The test shall not be conducted until the vessel and liquid are at approximately the same temperature.

(d) Defects detected during the hydrostatic test or subsequent examination shall be completely removed and then inspected. Provided the marine inspector gives his approval, they may then be repaired.

(e) Vessels requiring stress relieving shall be stress relieved after any welding repairs have been made. (See UW-40 of section VIII of the ASME Boiler and Pressure Vessel Code.)

(f) After repairs have been made the vessel shall again be tested in the regular way, and if it passes the test, the marine inspector may accept it. If it does not pass the test, the marine inspector can order supplementary repairs, or, if in his judgment the vessel is not suitable for service, he may permanently reject it.

[CGFR 68-82, 33 FR 18828, Dec. 18, 1968, as amended by USCG-2003-16630, 73 FR 65170, Oct. 31, 2008]

§ 54.10-15 Pneumatic test (modifies UG-100).

(a) Pneumatic testing of welded pressure vessels shall be permitted only for those units which are so designed and/or supported that they cannot be safely filled with water, or for those units which cannot be dried and are to be used in a service where traces of the testing medium cannot be tolerated.

(b) Proposals to pneumatically test shall be submitted to the cognizant Officer in Charge, Marine Inspection, for approval.

(c) Except for enameled vessels, for which the pneumatic test pressure shall be at least equal to, but need not exceed, the maximum allowable working pressure to be marked on the vessel, the pneumatic test pressure shall be at least equal to one and one-tenth (1.10) times the maximum allowable working pressure to be stamped on the vessel multiplied by the lowest ratio (for the materials of which the vessel is constructed) of the stress value “S” for the test temperature of the vessel to the stress value “S” for the design temperature (see UG-21 of section VIII of the ASME Boiler and Pressure Vessel Code (incorporated by reference; see 46 CFR 54.01-1)). In no case shall the pneumatic test pressure exceed one and one-tenth (1.10) times the basis for calculated test pressure as defined in UA-60(e) of section VIII of the ASME Boiler and Pressure Vessel Code.

(d) The pneumatic test of pressure vessels shall be accomplished as follows:

(1) The pressure on the vessel shall be gradually increased to not more than half the test pressure.

(2) The pressure will then be increased at steps of approximately one-tenth the test pressure until the test pressure has been reached.

(3) The pressure will then be reduced to the maximum allowable working pressure of the vessel to permit examination.

(e) Pressure vessels pneumatically tested shall also be leak tested. The test shall be capable of detecting leakage consistent with the design requirements of the pressure vessel. Details of the leak test shall be submitted to the Commandant for approval.

(f) After satisfactory completion of the pneumatic pressure test, the vessel may be stamped in accordance with § 54.10-20. A marine inspector shall observe the pressure vessel in a loaded condition at the first opportunity following the pneumatic test. The tank supports and saddles, connecting piping, and insulation if provided shall be examined to determine if they are satisfactory and that no leaks are evident.

(g) The pneumatic test is inherently more hazardous than a hydrostatic test, and suitable precautions shall be taken to protect personnel and adjacent property.

[CGFR 68-82, 33 FR 18828, Dec. 18, 1968, as amended by USCG-2003-16630, 73 FR 65170, Oct. 31, 2008]

§ 54.10-20 Marking and stamping.

(a) *Pressure vessels (replaces UG-116, except paragraph (k), and UG-118).* Pressure vessels that are required by § 54.10-3 to be stamped with the Coast Guard Symbol must also be stamped with the following information:

(1) Manufacturer's name and serial number.

(2) Coast Guard number, see § 50.10-30 of this subchapter.

(3) Coast Guard Symbol, which is affixed only by the marine inspector.

(4) Maximum allowable working pressure ____ kPa (____ psig) at ____ °C (____ °F).

(5) Class.

(6) Minimum design metal temperature, if below -18 °C (0 °F).

(7) Water capacity in liters (U.S. gallons), if a cargo carrying pressure vessel.

(b) *Multichambered pressure vessels (replaces UG-116(k)).* In cases where more than one pressure vessel is involved in an integral construction, as with a heat exchanger, the manufacturer may elect to class the component pressure vessels differently. In such cases he shall stamp the combined structures as required in paragraph (a) of this section with information for each pressure vessel. Where an item for stamping is identical for both vessels, as with name and address of manufacturer, it need not be duplicated. However, where differences exist, each value and the vessel to which it applies shall be clearly indicated.

(c) *Stamping data (replaces UG-117).* Except as noted in paragraph (d) of this section, the data shall be stamped directly on the pressure vessel. The data shall be legibly stamped and shall not be obliterated during the service life of the pressure vessel. In the event that the portion of the pressure vessel upon which the data is stamped is to be insulated or otherwise covered, the data shall be reproduced on a metal nameplate. This plate shall be securely attached to the pressure vessel. The nameplate shall be maintained in a legible condition such that it may be easily read.

(1) Those parts of pressure vessels requiring Coast Guard shop inspection under this part which are furnished by other than the shop of the manufacturer responsible for the completed vessel shall be stamped with the Coast Guard Symbol, the Marine Inspection Office identification letters (see § 50.10-30 of this subchapter) and the word "Part", the manufacturer's name and serial number, and the design pressure.

(d) *Thin walled vessels (Modifies UG-119).* In lieu of direct stamping on the pressure vessel, the information required by paragraph (a) of this section shall be stamped on a nameplate permanently attached to the pressure vessel when the pressure vessel is constructed of—

(1) Steel plate less than one-fourth inch thick; or